

FIG. 1

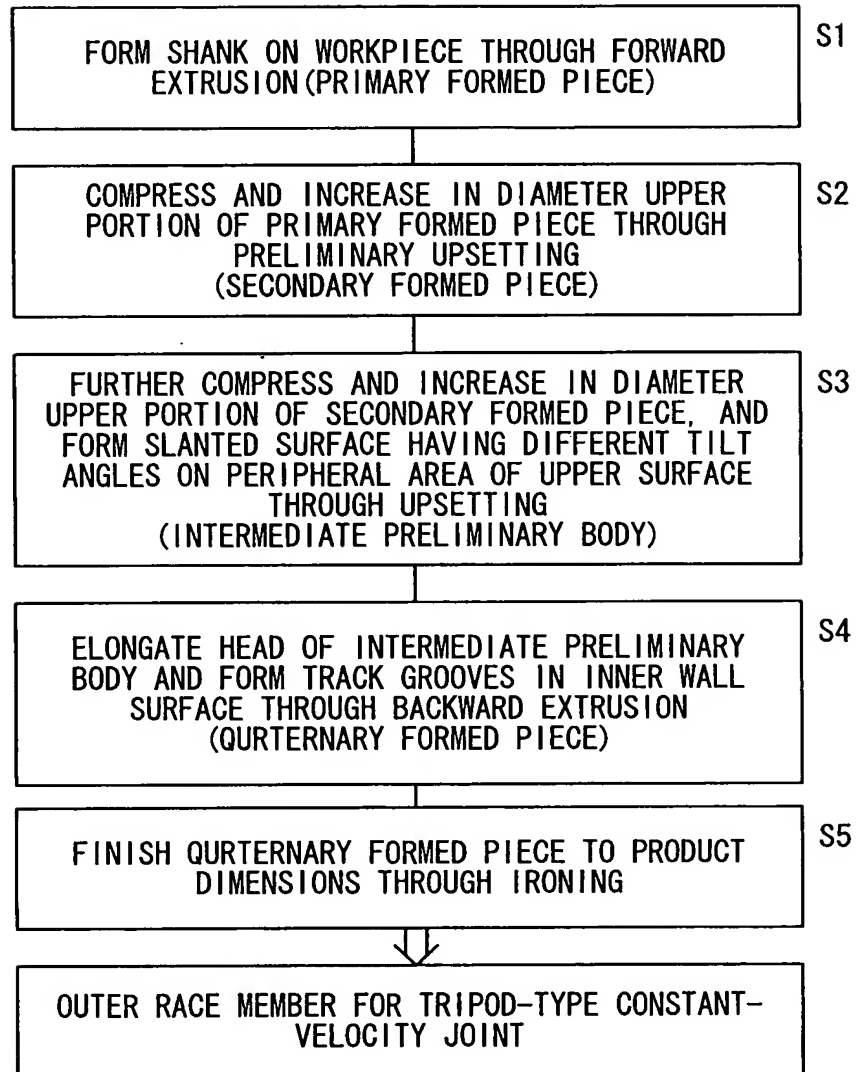
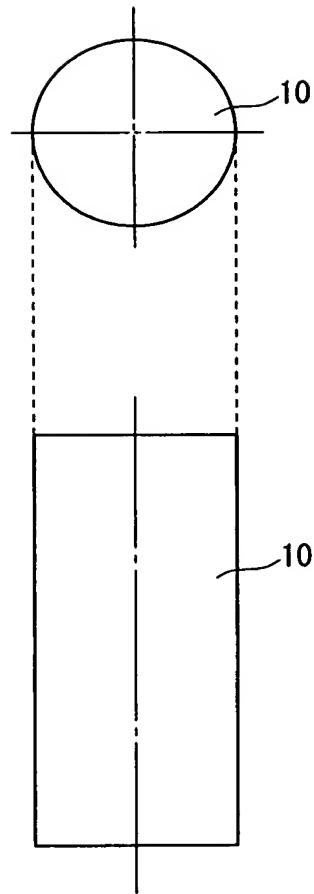
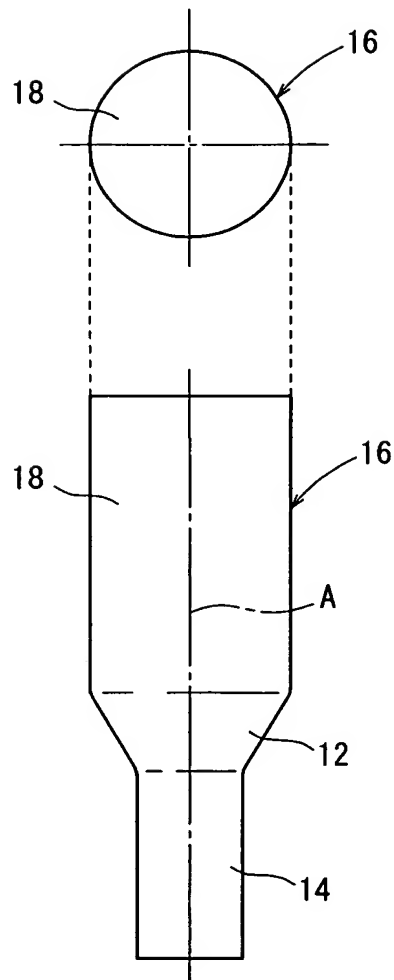


FIG. 2



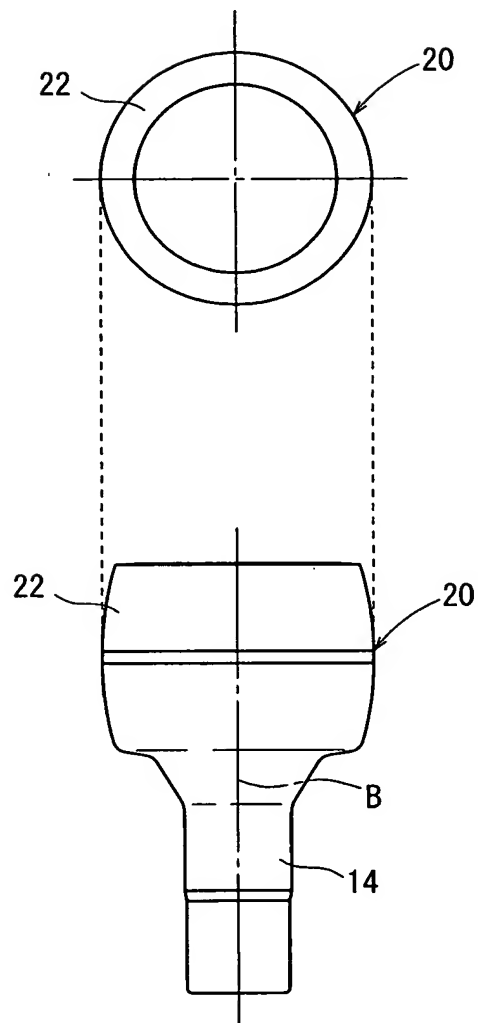
(WORKPIECE)

FIG. 3



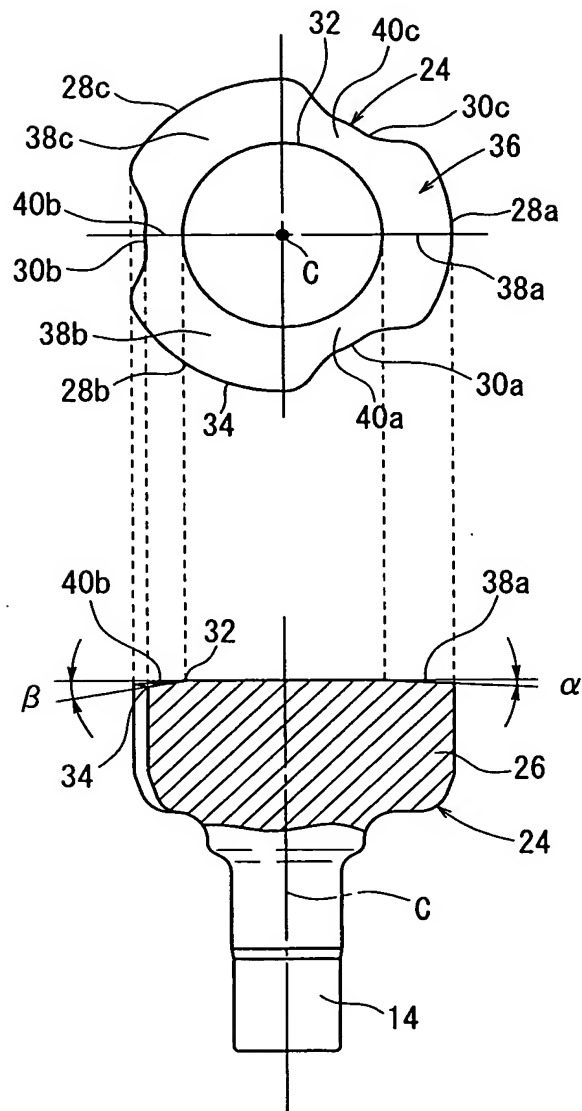
(PRIMARY FORMED PIECE)

FIG. 4



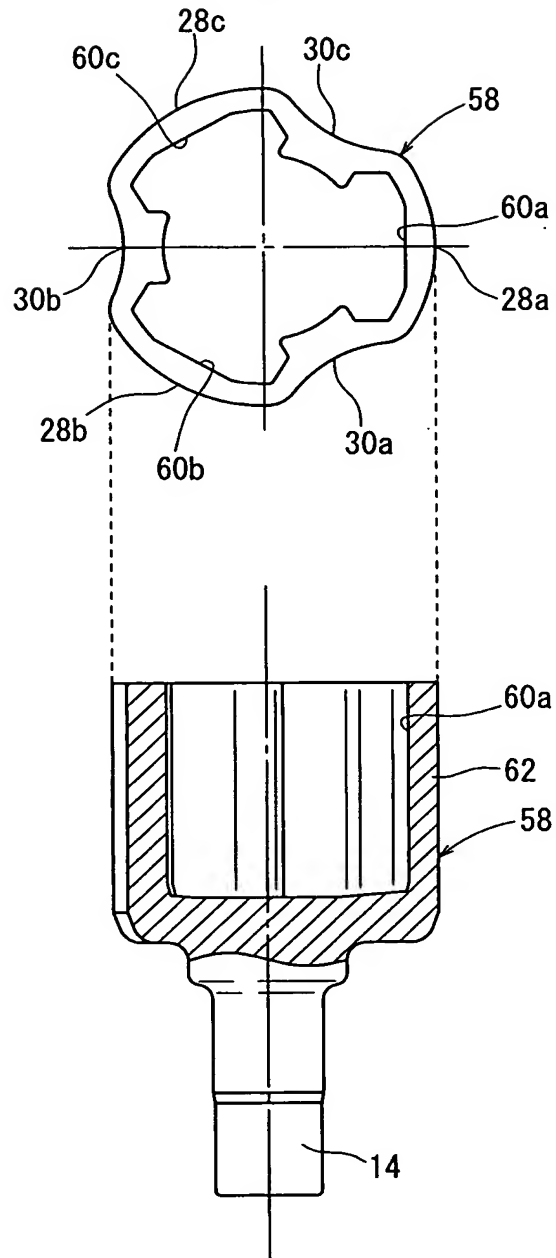
(SECONDARY FORMED PIECE)

FIG. 5



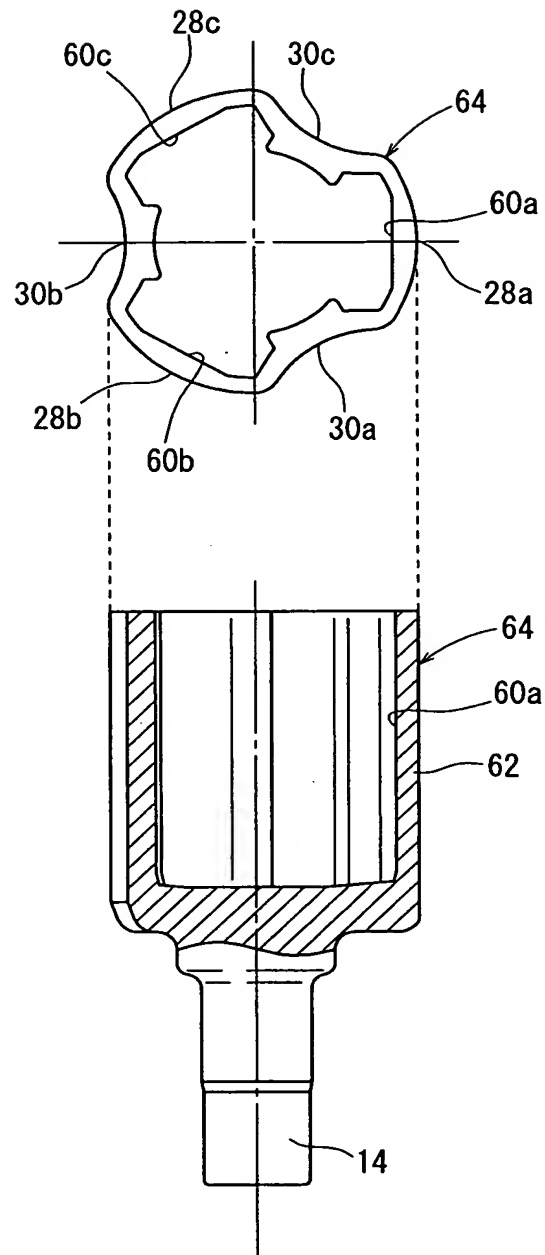
(INTERMEDIATE PRELIMINARY BODY)

FIG. 6



(QURTERNARY FORMED PIECE)

FIG. 7



(COMPLETED PRODUCT)

FIG. 8

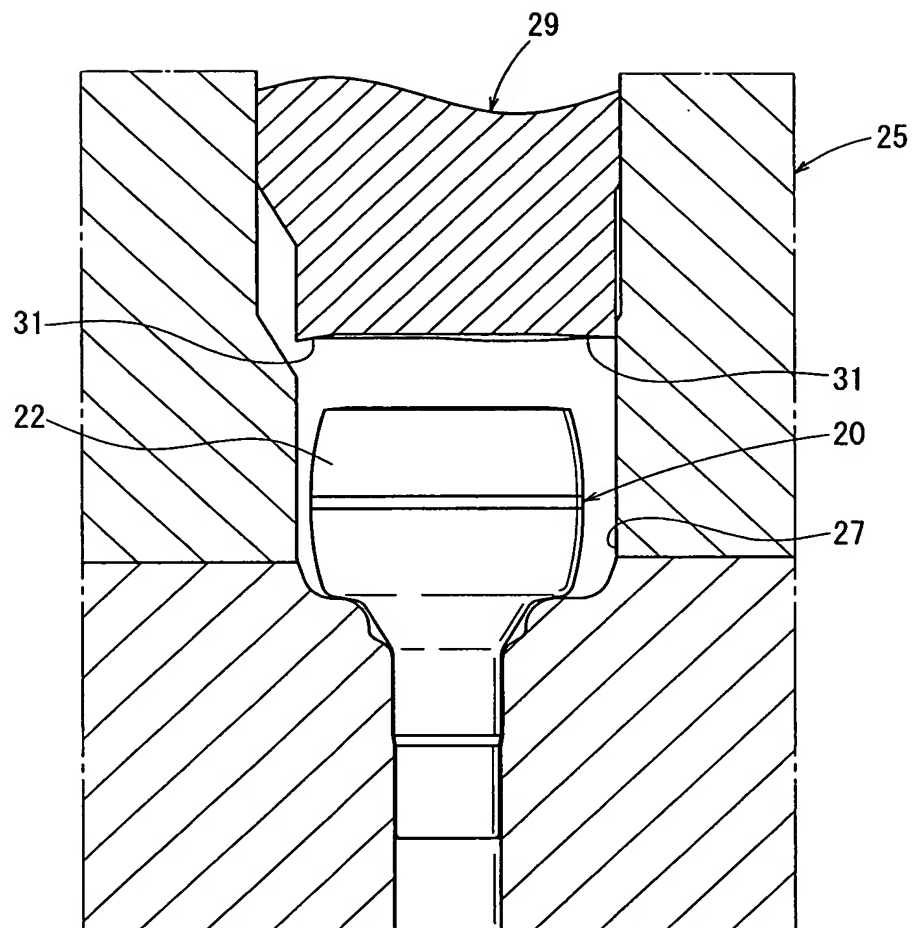




FIG. 9

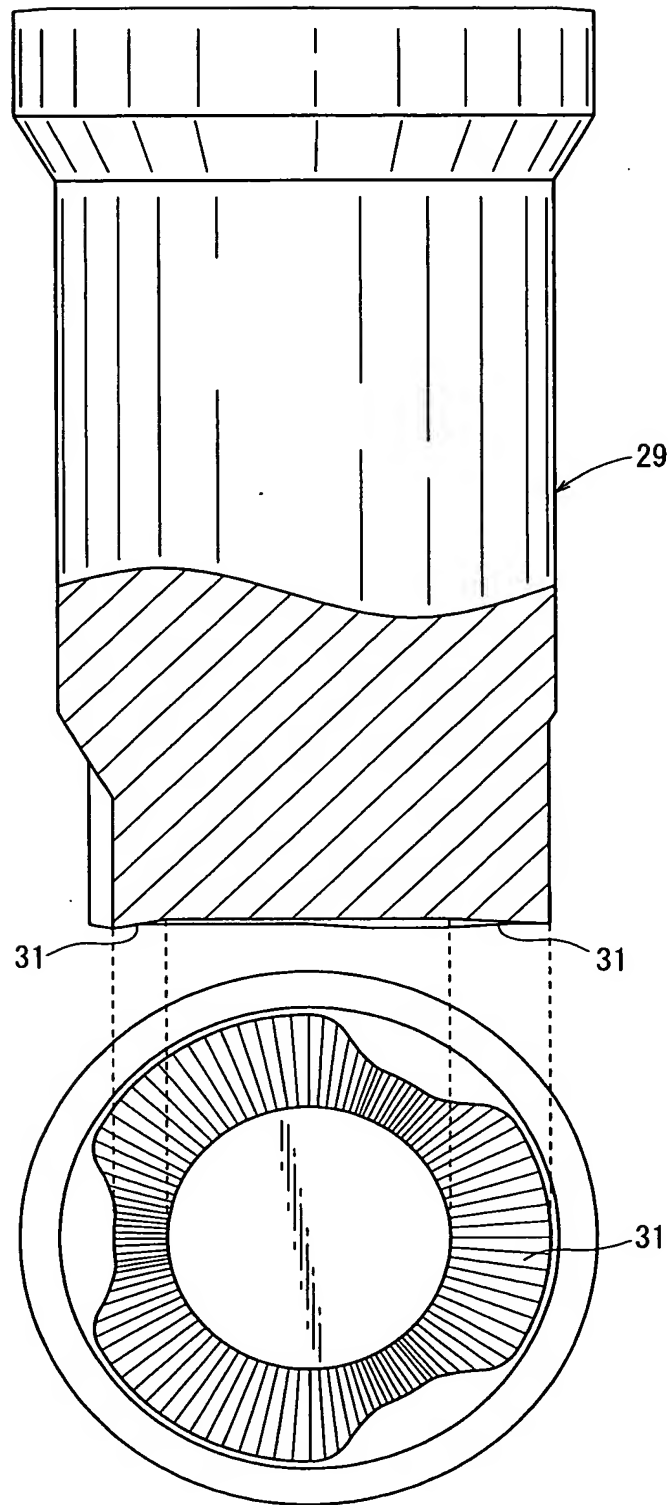


FIG. 10

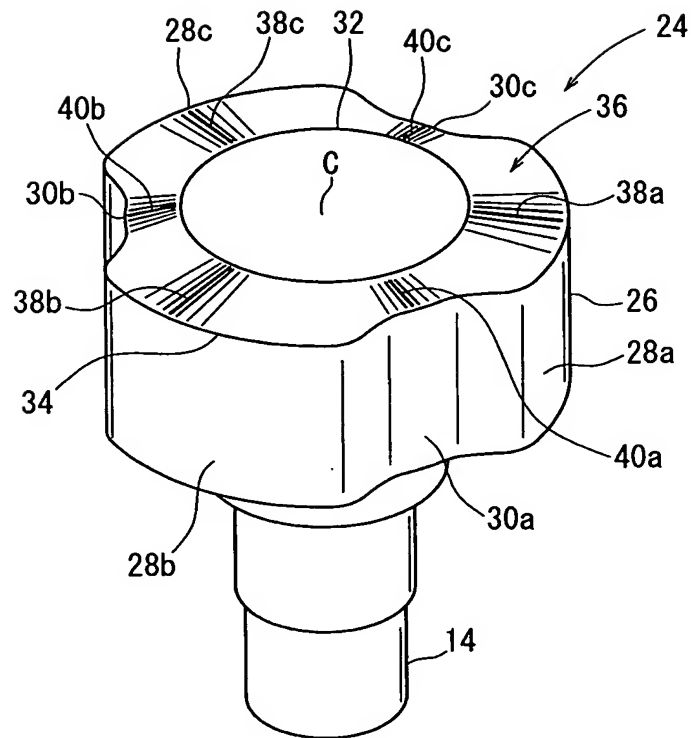


FIG. 11

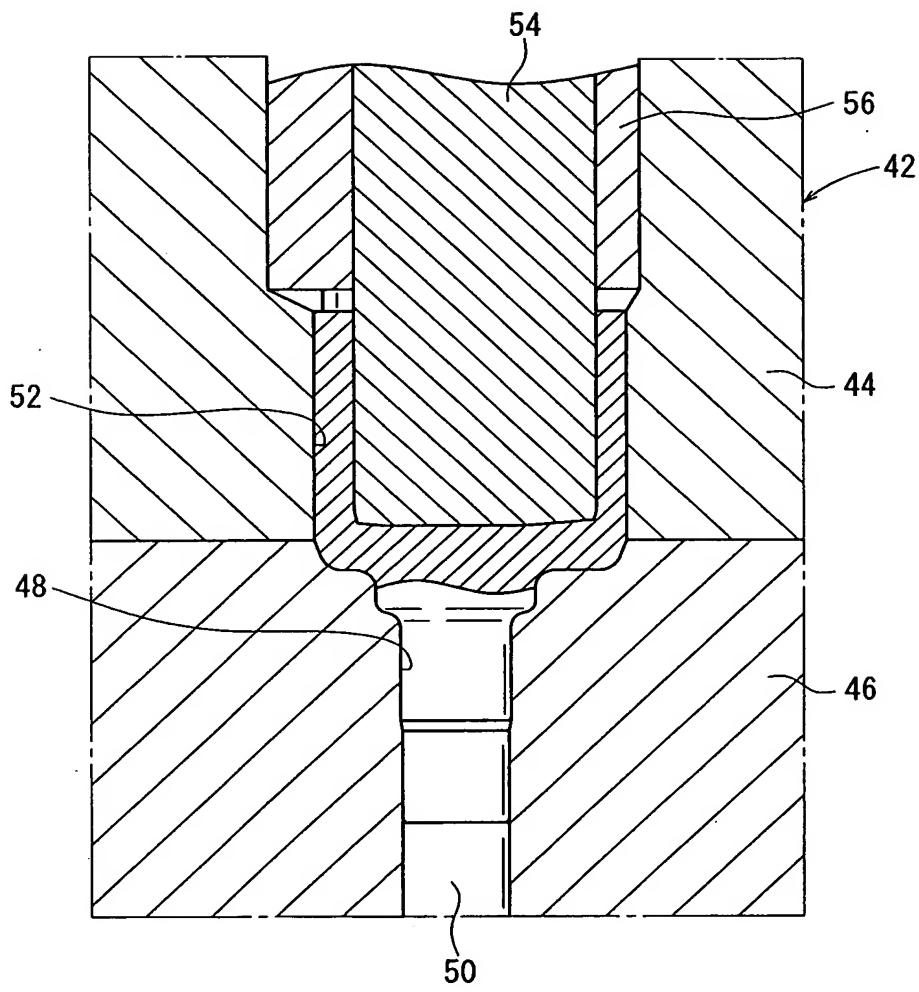


FIG. 12

LARGER-DIAMETER PORTIONS ( $\alpha$ )	SMALLER-DIAMETER PORTION ( $\beta$ )	ANGLE DIFFERENCE	HOW MATERIAL IS FILLED	FORMED BODY IN NEXT STEP	JUDGEMENT
3°	3°	0°	$\Delta$	PROBLEM IN PLACING FORMED BODY IN DIE	$\Delta$
	6°	3°	$\bigcirc$	NO PROBLEM	$\bigcirc$
	9°	6°	$\bigcirc$	NO PROBLEM	$\bigcirc$
	10°	7°	$\bigcirc$	NO PROBLEM	$\bigcirc$
	12°	9°	$\bigcirc$	NO PROBLEM	$\bigcirc$
	15°	12°	$\bigcirc$	NO PROBLEM	$\bigcirc$
	18°	15°	$\odot$	MATERIAL CRACKING	$\times$

FIG. 13

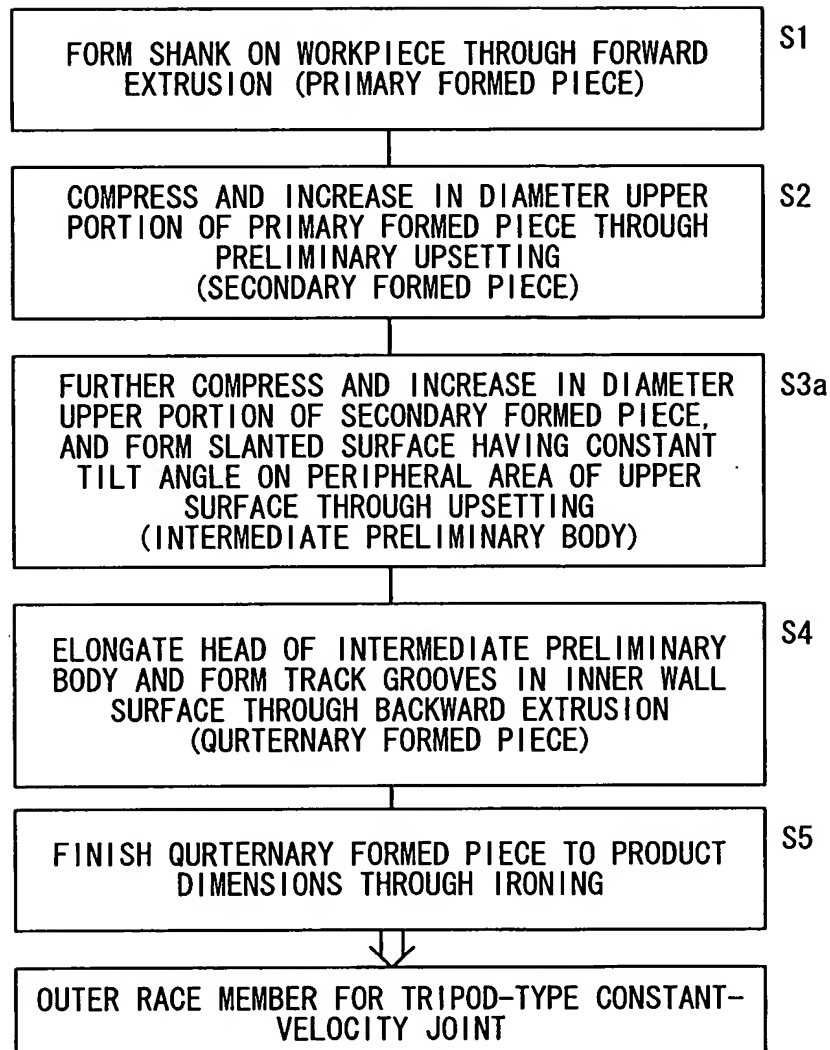
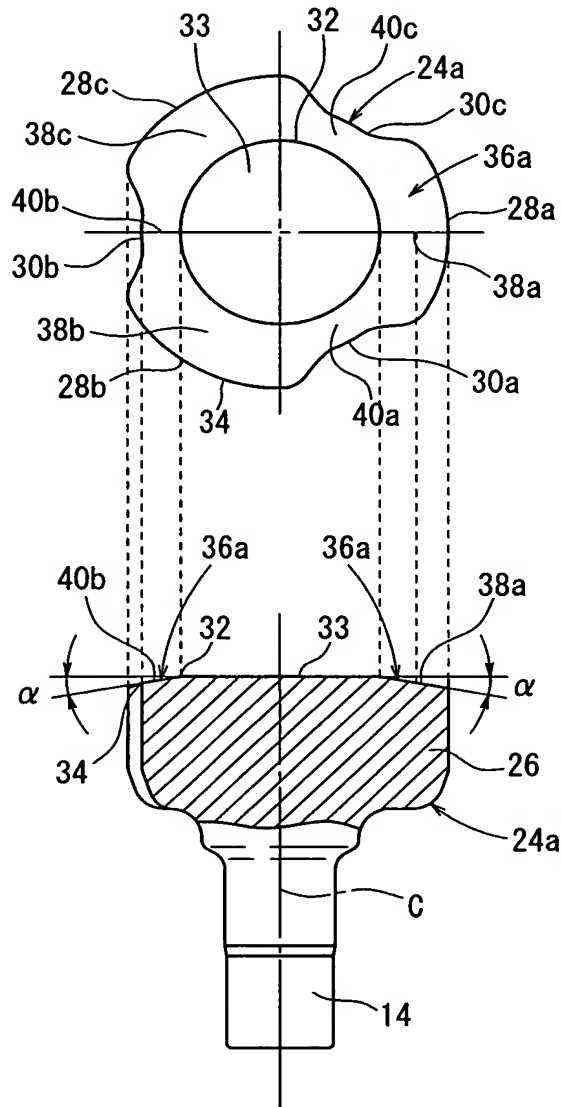


FIG. 14



(INTERMEDIATE PRELIMINARY BODY)

FIG. 15

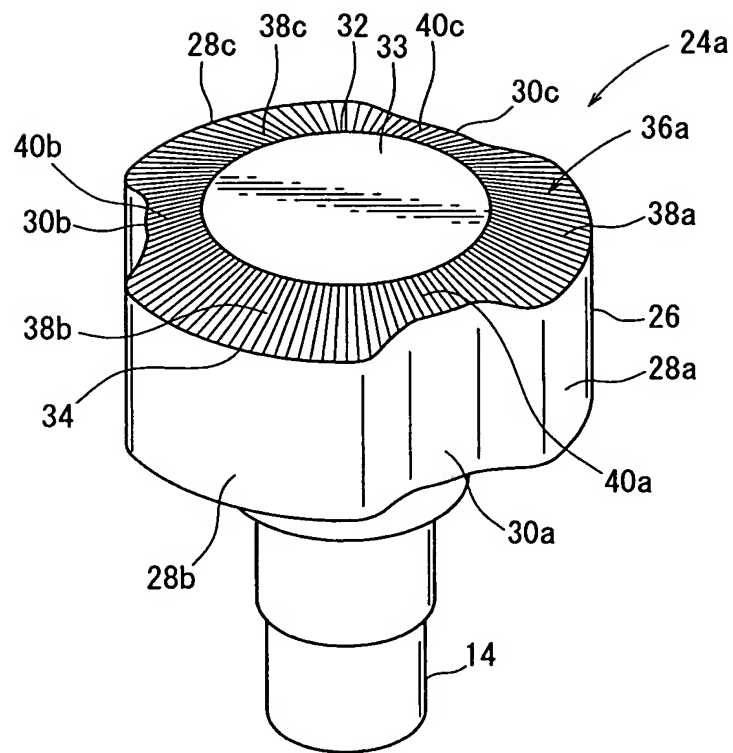


FIG. 16

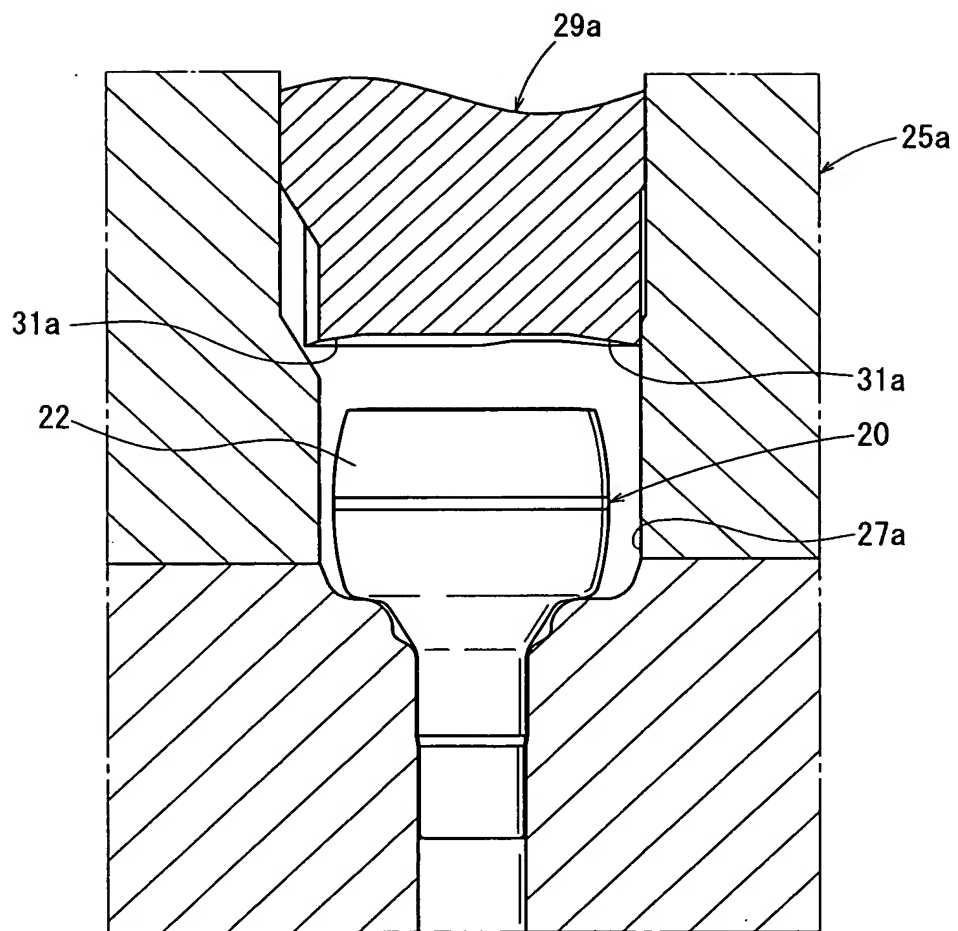




FIG. 17

